Work Order ID 60096

June 24, 2010 9:18:22 AM

Item ID: D2561 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Lug

Start Date: 6/24/10 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 7/02/10 **Req'd Qty:** 30.00 **Customer:**

Reference:

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2561	**Revision Nbr** Rev B								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet 6061 .250X6"	1-Cut as per Dwg D2561 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

MAT NOT PULLED

B 10-6-24

34

B 10-6-24

S w/ 06/25

counted x34

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Deburr , no sharp edges								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: N/A	0.00							
Packaging	**Memo**	0.00							
Packaging									

34X

=7 M.L 6/06/25

counted

X34

5 labels

K 10.08.30 34

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 60096

June 24, 2010 9:18:23 AM

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							10/09/01
QC	**Memo**	0.00							
Quality Control									

YMF
10-9-1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:18:21 AM

Work Order ID: 60096

Parent Item: D2561

Parent Item Name: Lug

Start Date: 6/24/10 **Required Date:** 7/02/10

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP C□ 00.05.19□Added inspect level 8□EC
IPP Rev:D Now on Waterjet 06-06-14 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.000		Purchased	No			100	f	2.5800	0.3667	11.58	12.5		

6061-T6 Bar .250 x 6.00

HB 10-6-24

Location	Loc Qty	Loc Code
MAT01	2.58	
113181	2.58	

~~113181~~ X 22 = (34) 8.1

m6061T6B .250 · SHEET 112663

112663 X 12 = 4.4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66096
Description: Lug Plate	Part Number:	D2561
Inspection Dwg: D2561 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.505	✓			
2.525	+/-0.010	2.524	✓			
3.975	+/-0.010	3.983	✓			
Ø0.257	+0.005/-0.000	.258	✓			
4.525	+/-0.010	4.529	✓			
5.025	+/-0.010	5.028	✓			
0.25	+/-0.030	.250	✓			

Measured by:	IB
Date:	10-6-24

Audited by:	
Date:	10/06/25

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	09.05.21	Dimensions updated	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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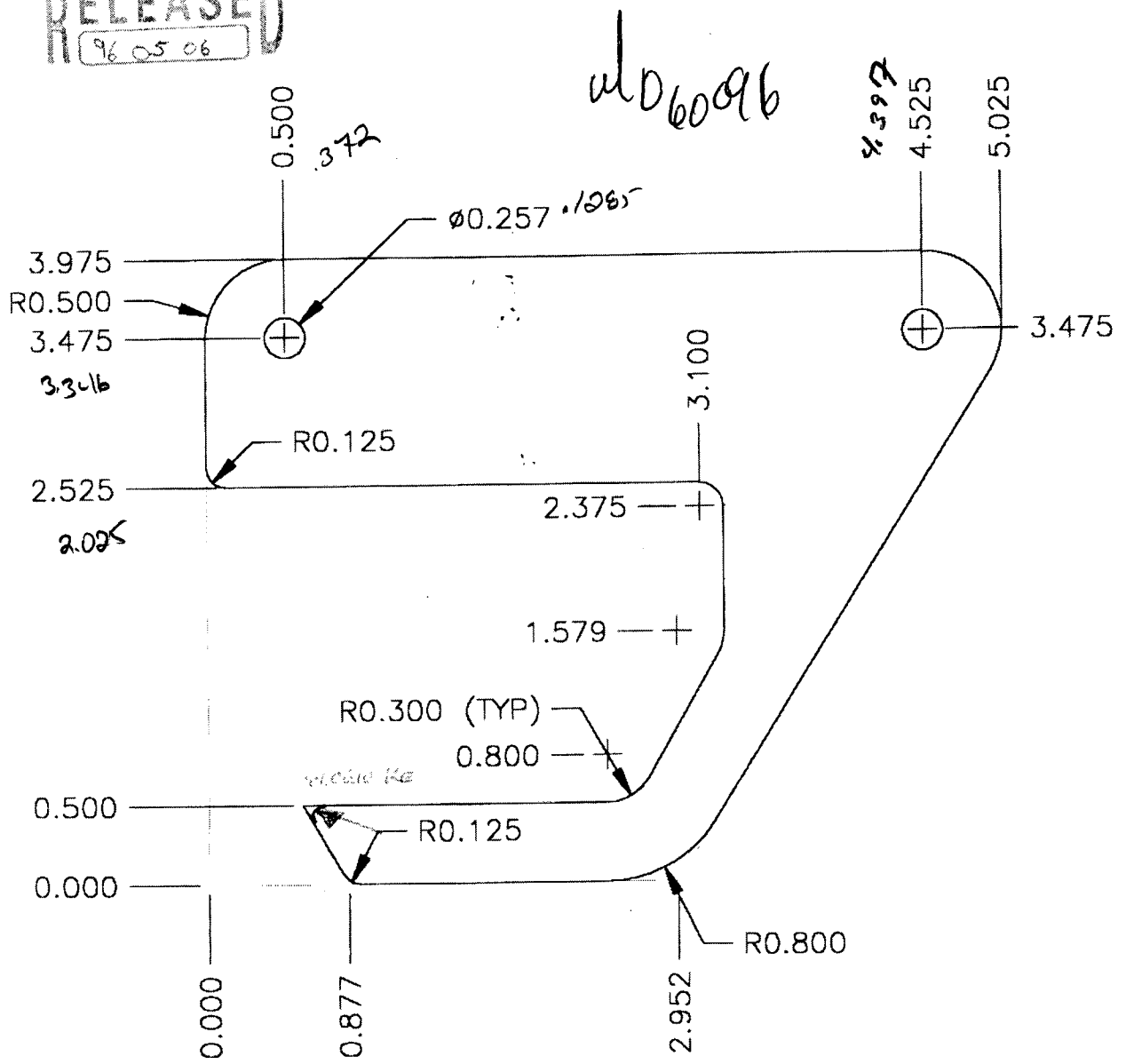
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2561	SHEET 1 OF 1
DATE		TITLE	SCALE
96.04.26		LUG PLATE	1:1

DART

COPY ISSUED

RELEASED
96 05 06



MATERIAL: 6061–T6 0.25 THICK
OR 6063–T6 0.25 THICK
OR 5052–H34 0.25 THICK

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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